

Work Order ID 73107



Page 1

Thursday, August 25, 2011 4:03:37 PM

Item ID: D3278-041

Accept



Setup Start



Revision ID:

Item Name: Support Assembly

Stop



Start Date: 8/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan:

CL

Date: 11/08/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3278

Rev C

100



Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Rivet spacers with support as per Dwg D3278.

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

120



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble support as per Dwg D3278. ***DO NOT TIGHTEN
BOLTS*** Identify as D3278-041

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Stop

Sequence ID/
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DescriptionSet Up/
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Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S u l c o l i p

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NOTE: Date & initial all entries

Picklist Print

Page 1

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Work Order ID: 73107



Parent Item: D3278-041



Parent Item Name: Support Assembly

Start Date: 8/26/2011

Required Date: 10/14/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A 04.04.19 New issue KJ/JLM
 IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 		Manufactured	No			100	Each	5.0000	1	40		<i>B11/10/11</i>	<i>B69889 35X</i>
Support							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				GA			5						
				68956			5						
D3278-2 		Manufactured	No			100	Each	0.0000	1	40		<i>B11/10/11</i>	<i>B73412 52</i>
Support				<i>B73413 5X</i>			<i>B69888 35X</i>						
D3278-3 		Manufactured	No			100	Each	100.0000	1	40		<i>B11/10/11</i>	
Spacer							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				GA			100						
				68340			34						
				70984			66						
MS21042L4 		Purchased	No			100	Each	4,143.000	2	80		<i>40</i>	<i>80</i>
Nut							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
				ST300			4143						
				117441			57						
				117601			637						
				117885			1449						
				118451			2000						

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Parent Item Name: Support Assembly

Start Date: 8/26/2011

Required Date: 10/14/2011

Start Qty: 40.00

Required Qty: 40.00

AN4-13A



Purchased

No

120

Each

846.0000

2

80



Bolt

Location

Loc Qty

Loc Code

ST357	846	
118078	594	
118351	252	

M118706

804

AN960JD416



NAS1149D0463J

Purchased

No

M117591 (20x)

120

Each

0.0000

4

160



Washer

D2230-I



Manufactured

No

120

Each

225.0000

2

80



Lug

Location

Loc Qty

Loc Code

ST476	225	
67826	6	
69179	19	
69821	100	
70974	100	

80

MS20426AD3-6



Purchased

No

120

Each

3,525.000

4

160



Rivet

Location

Loc Qty

Loc Code

ST316	3525	
105055	115	
116289	3410	

160

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

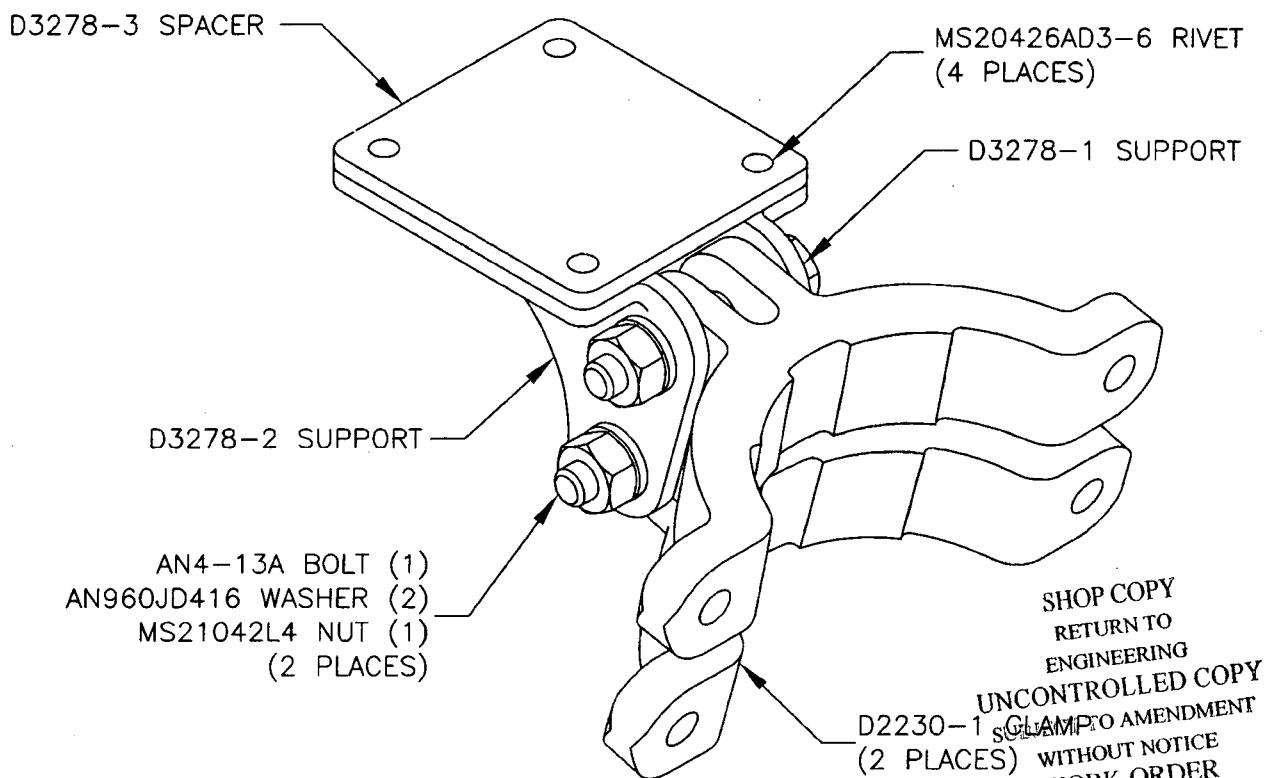
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DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>JL</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS

RELEASED
07.08.08D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description	No.
X	D3278-041	SUPPORT ASSEMBLY	<i>CD41108124</i>
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

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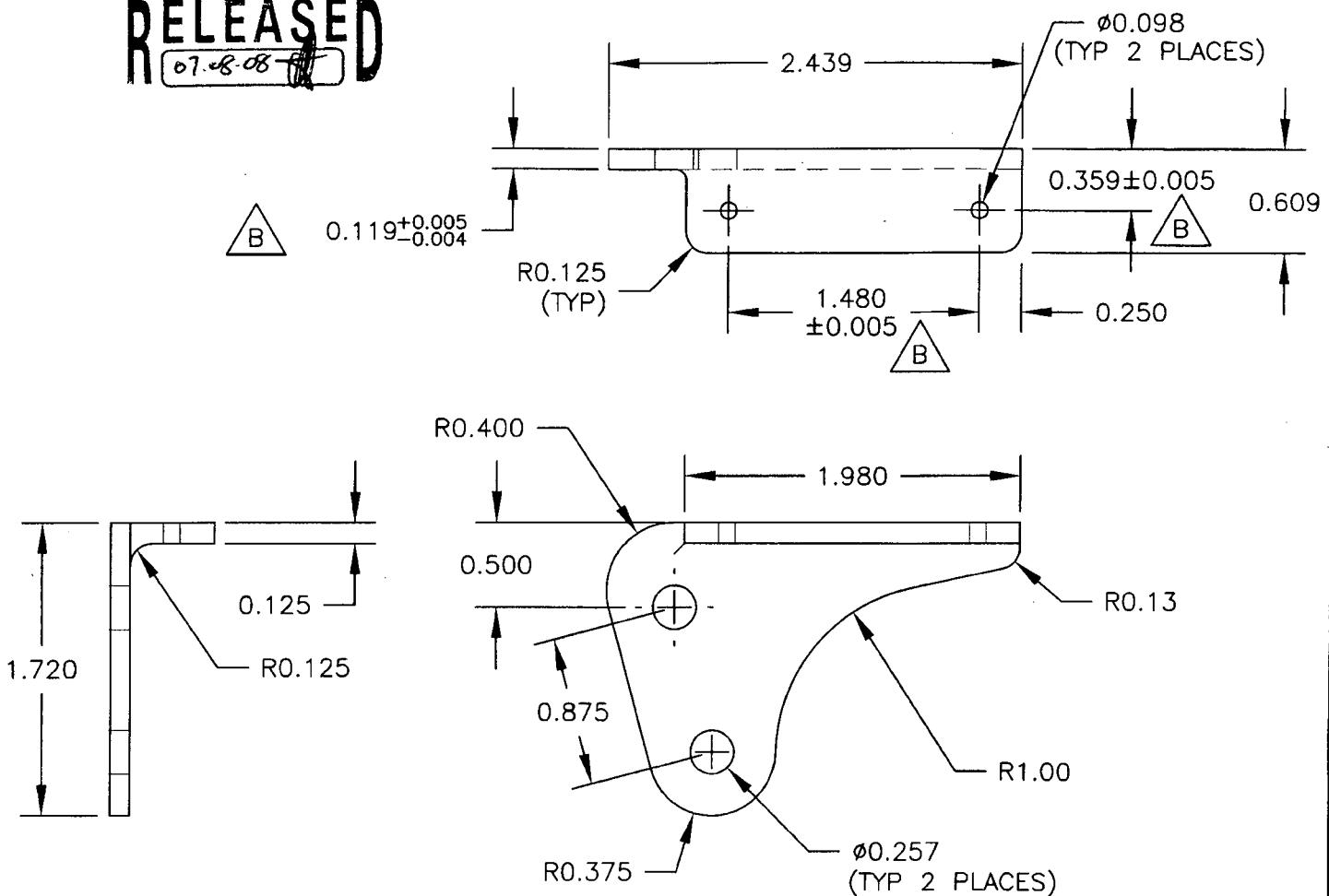
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DESIGN <i>QP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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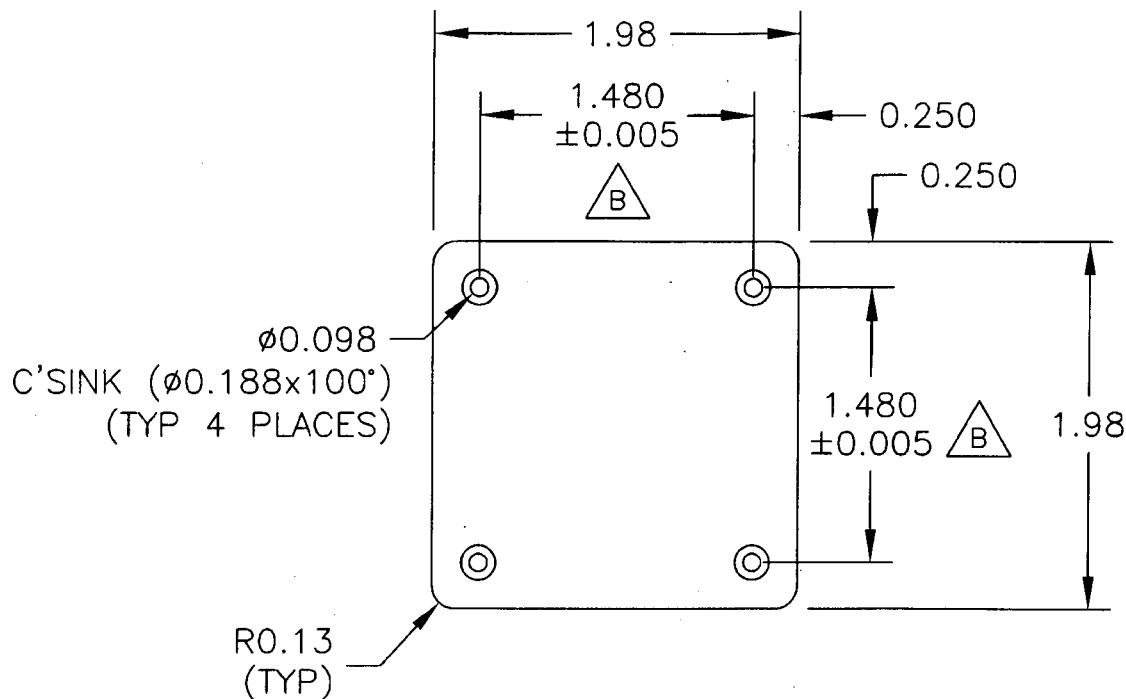
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DART

DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278
DATE 07.07.24	TITLE	REV. C SHEET 3 OF 3 SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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